







Split

Work Order ID 52660 - 2

October 5, 2009 2:53:38 PM

Page 1

Item ID:	D206-547-043 BK	Accept		Setup	Start	
Revision ID:	F				Stop	
Item Name:	Console High Slope					
Start Date:	05/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	27/10/2009	Req'd Qty:	6.00	Customer:		
Reference:						
Approvals:	Process Plan: <u>RP</u>	Date: <u>07-10-5</u>	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-547	Rev F								
100	Small Fab	0.00							
									
Small Fab	Memo	0.00							
Small Fab	1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4								
110	Small Fab	0.00							
									
Small Fab	Memo	0.00							
Small Fab	1-Grind weld relief chamfer as per Dwg D206-547								
	2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

09/10/19 (8)

09/10/20 (8)

KSKH
KSKH

→ 08/10/21

Work Order ID 52660

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Page 2

Item ID: D206-547-043
Revision ID: F
Item Name: Console High Slope

Accept



Setup Start



Stop



Start Date: 06/10/2009 Start Qty: 6.00
Required Date: 27/10/2009 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

Large Fab

Memo

1-Tack weld as per Dwg D206-547□A/R

Batch: HA108436

2-GRIND

0.00

0.00

AL ROD

Pl 09 10 23

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2> 809/10/26

*X66H
X66H*

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

2> 809/10/26

*X66H
X66H*

Work Order ID 52660

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Page 3

Item ID: D206-547-043
Revision ID: F
Item Name: Console High Slope

Accept



Setup Start



Stop



Start Date: 06/10/2009 Start Qty: 6.00
Required Date: 27/10/2009 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Small Fab

Small Fab

Small Fab

Memo

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

0.00

0.00

ES 09/11/06 (2)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> Sclulob

(2)

180



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

11109091

Memo

START TIME:

11:30a FINISH TIME:

0.00

0.00

=> 09/4/4

(2)

OVEN TEMPERATURE:

320F

Work Order ID 52660



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November 11, 2009 1:16:26 PM

Item ID: D206-547-043

Accept



Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 10/06/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

SK

09-11-11

(2)



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/11/11

SP (2x) SP

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/12

MF

09-11-12

Picklist Print

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Page 1

Work Order ID: 52660

Parent Item: D206-547-043RevF

Parent Item Name: Console High Slope

Start Date: 06/10/2009

Required Date: 27/10/2009

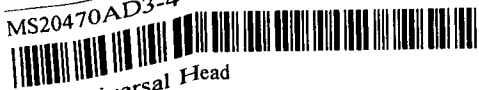
Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD3-4



Rivet, Universal Head

Purchased

No

100

Each

12,043.00

120.0000



EP 09/10/20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12043

111477

8332

15541

3711

160

Manufactured

No

110

f

1,273.160

21.6000



EP 09/10/15

D2024RevC



Console Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1273.16

1

1273.16

101

Manufactured

No

110

Each

7.0000

6.0000



EP 09/10/11

D2602-1RevB



Console Side, 206 Console

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

43752

1

51779

6

B50406

(517)

Picklist Print

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Page 2

Work Order ID: 52660

Parent Item: D206-547-043RevF

Parent Item Name: Console High Slope

Comments:

Start Date: 06/10/2009

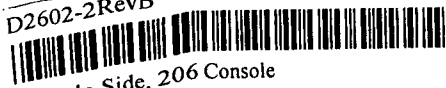
Required Date: 27/10/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2602-2RevB



Console Side, 206 Console

Manufactured

No

110

Each

7.0000

6.0000



EP 09/10/09

Warehouse

Loc Qty

Loc Code

Location

B52697 (8H)

Main Warehouse

ST

1

46249

1

Main Warehouse

ST177

6

50255

6

Manufactured

No

110

Each

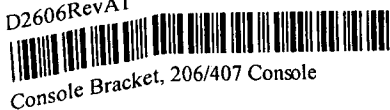
13.0000

6.0000



EP 09/11/09

D2606RevA1



Console Bracket, 206/407 Console

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

48442

13

53196

6
2

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Shop Packet Print

Page 2

icklist Print
 October 5, 2009 2:53:37 PM

Work Order ID: 52660
 Parent Item: D206-547-043RevF
 Parent Item Name: Console High Slope

Start Date: 06/10/2009

Required Date: 27/10/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/
 Item Name

Replacement
Item IDMfg/
PurchBin
ItemPrimary
LocationLast
LocationRoute
Seq IDUnit of
MeasureQty on
HandRemaining
Qty To PickQty
IssuedDate
Issued

Status

Manufactured

No

110

Each

23.0000

6.0000

EP 09/11/06

D2607RevA1

Bracket, 206 Console

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

23

32820

7

50327

16

110

Each

8,586.000

48.0000

EP 09/14/06

Purchased

No

MS20470AD3-3

Rivet, Universal Head

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

8586

1065

1435

16941

7151

16

October 5, 2009 2:53:37 PM

Shop Packet Print



RELEASED
99.03.05 RE

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52660 BA 09-10-3

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY		SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

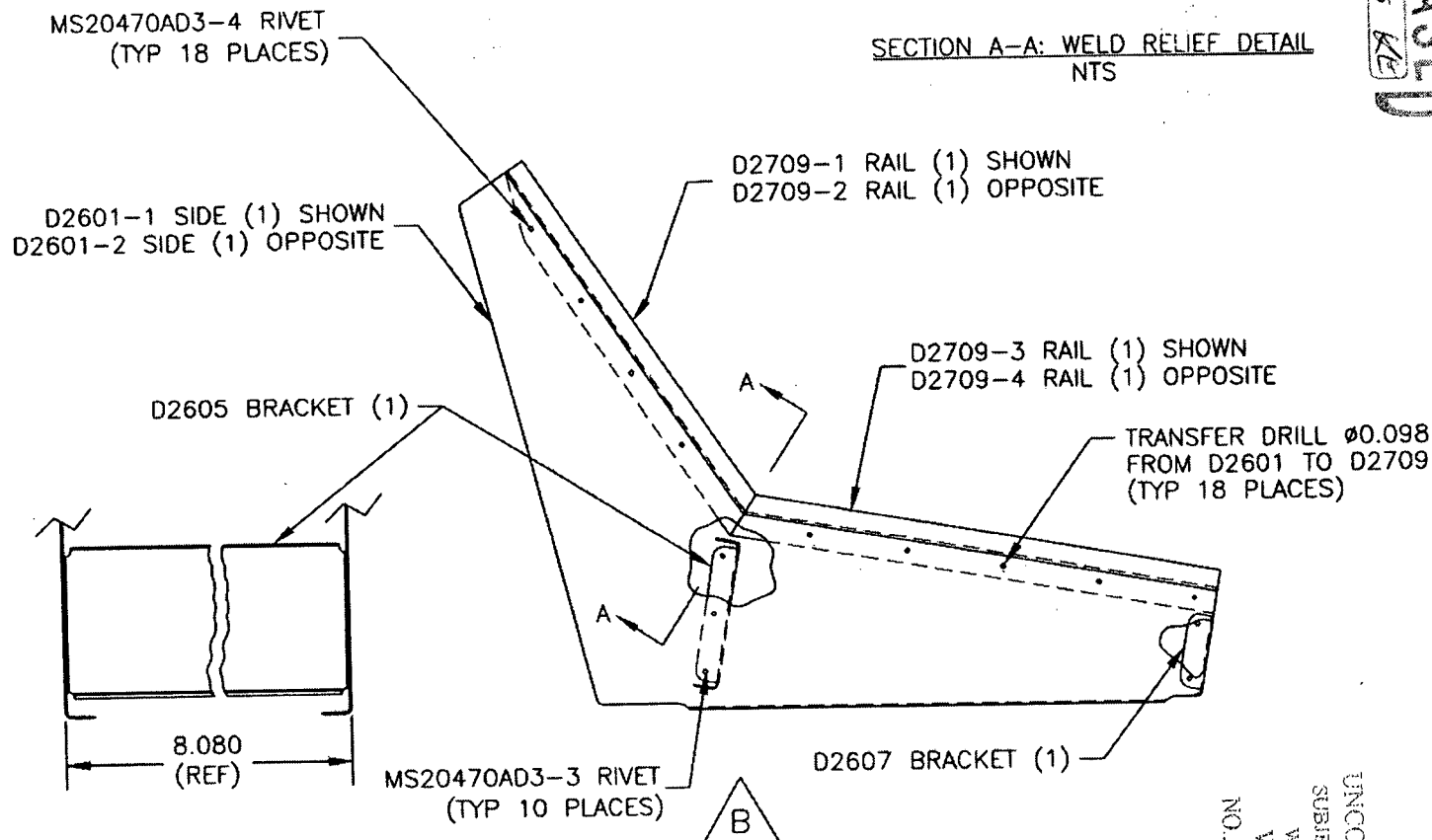
-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

DART

RELEASED
M0305 KE

GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 52660

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED JF	APPROVED KE	DRAWING NO. D206-547	SHEET 2 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

DART

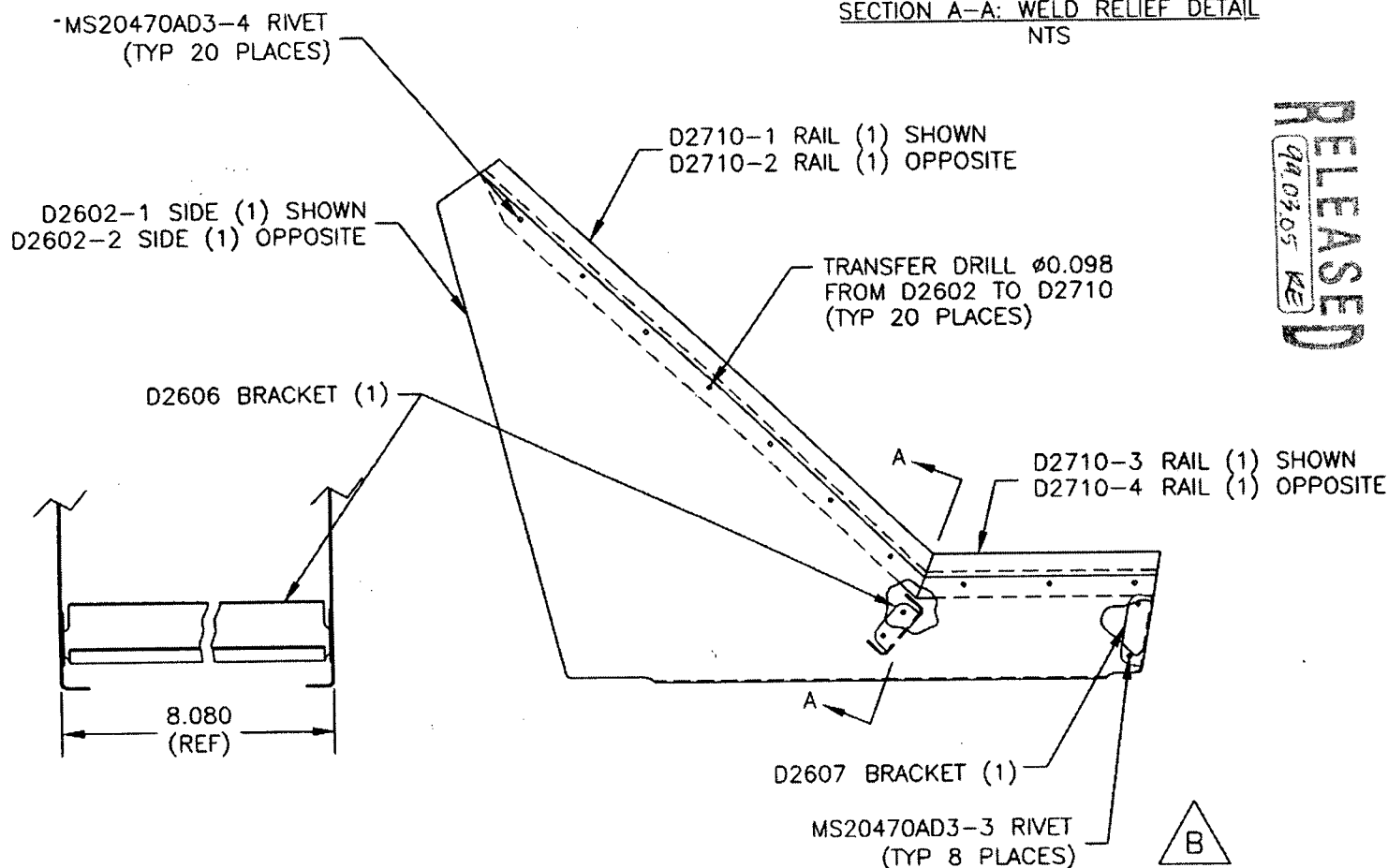
RELEASED
99.03.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
BW	RF	
CHECKED	APPROVED	DRAWING NO.
UP	KE	D206-547
DATE	TITLE	SHEET 3 OF 5
99.02.11	CONSOLE ASSEMBLY	SCALE 1:4



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS

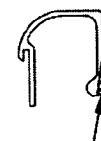


D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

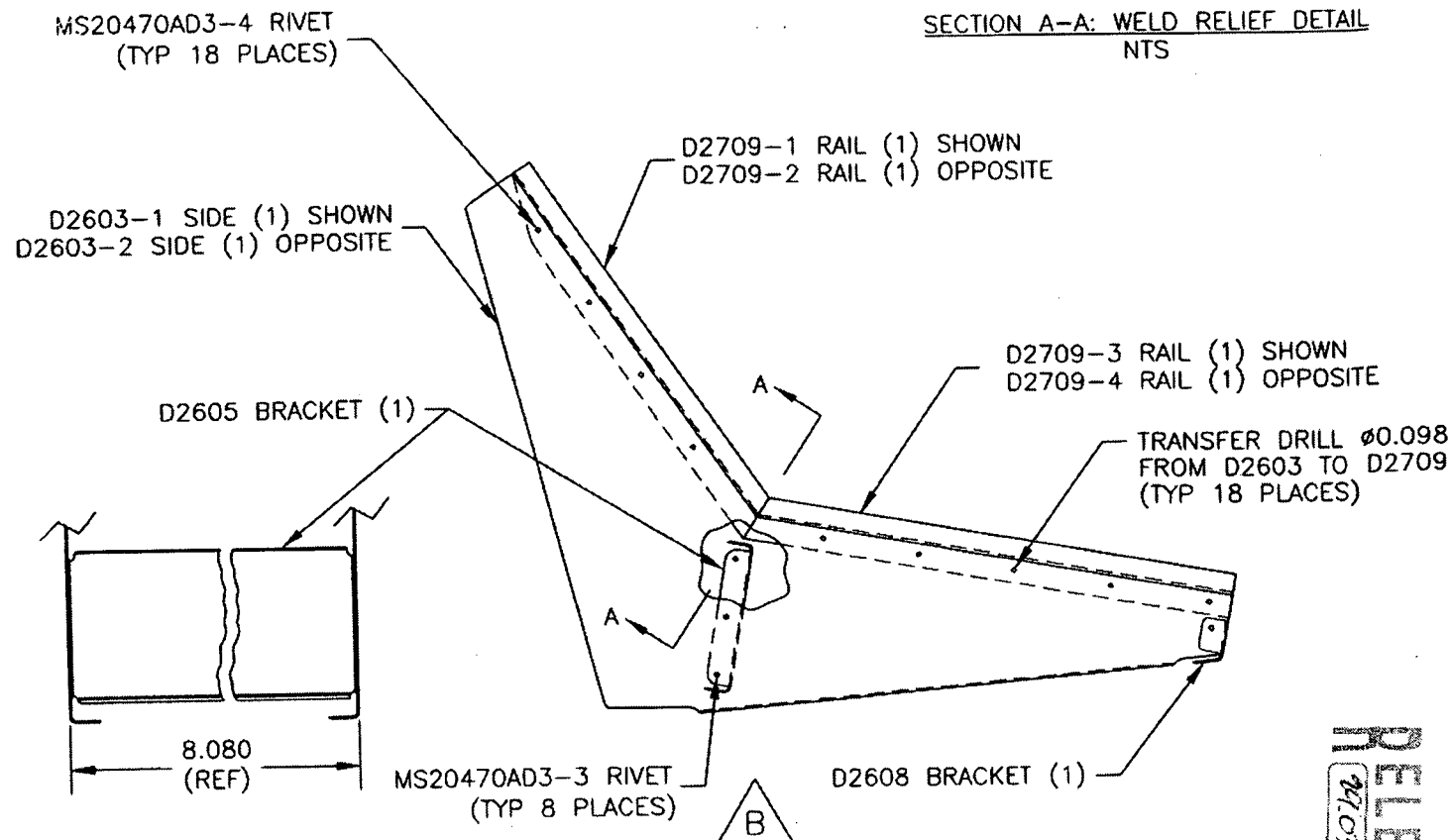
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WITHOUT NOTICE
WORK ORDER
NO. 52460

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN Bw	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5 SCALE 1:4

RELEASED
NOV 03 05 KE
SHOP COPY
RETURN TO
ENGINEERING

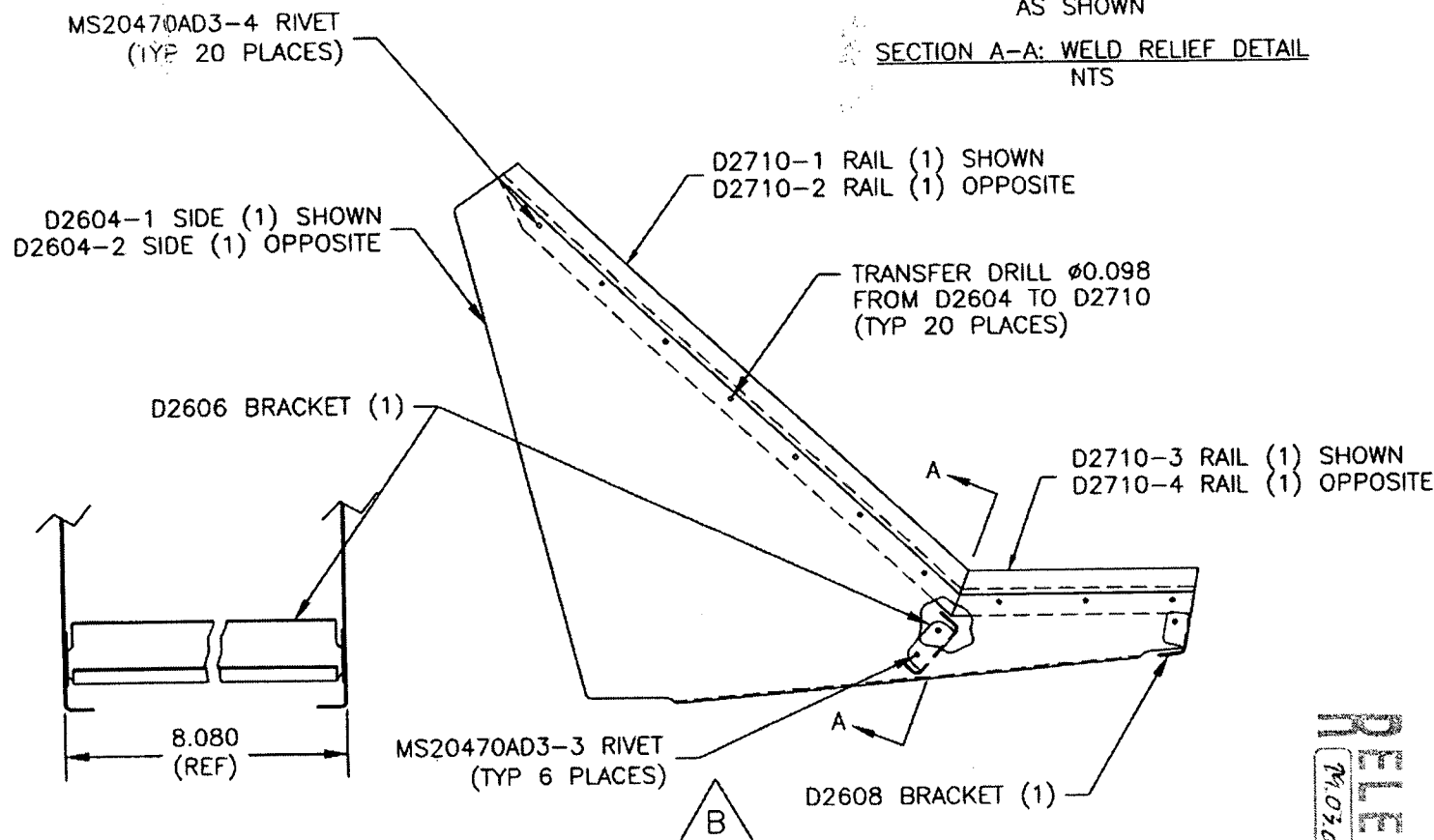
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
WORK COPY
NO. 526662

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	UP	APPROVED	KE	DRAWING NO. D206-547
DATE	99.02.11	TITLE	CONSOLE ASSEMBLY	REV. F SHEET 5 OF 5
		SCALE	1:4	

RELEASED
NO. 0705 KENDALL

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CONTROL LTD
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER

NO. 500000

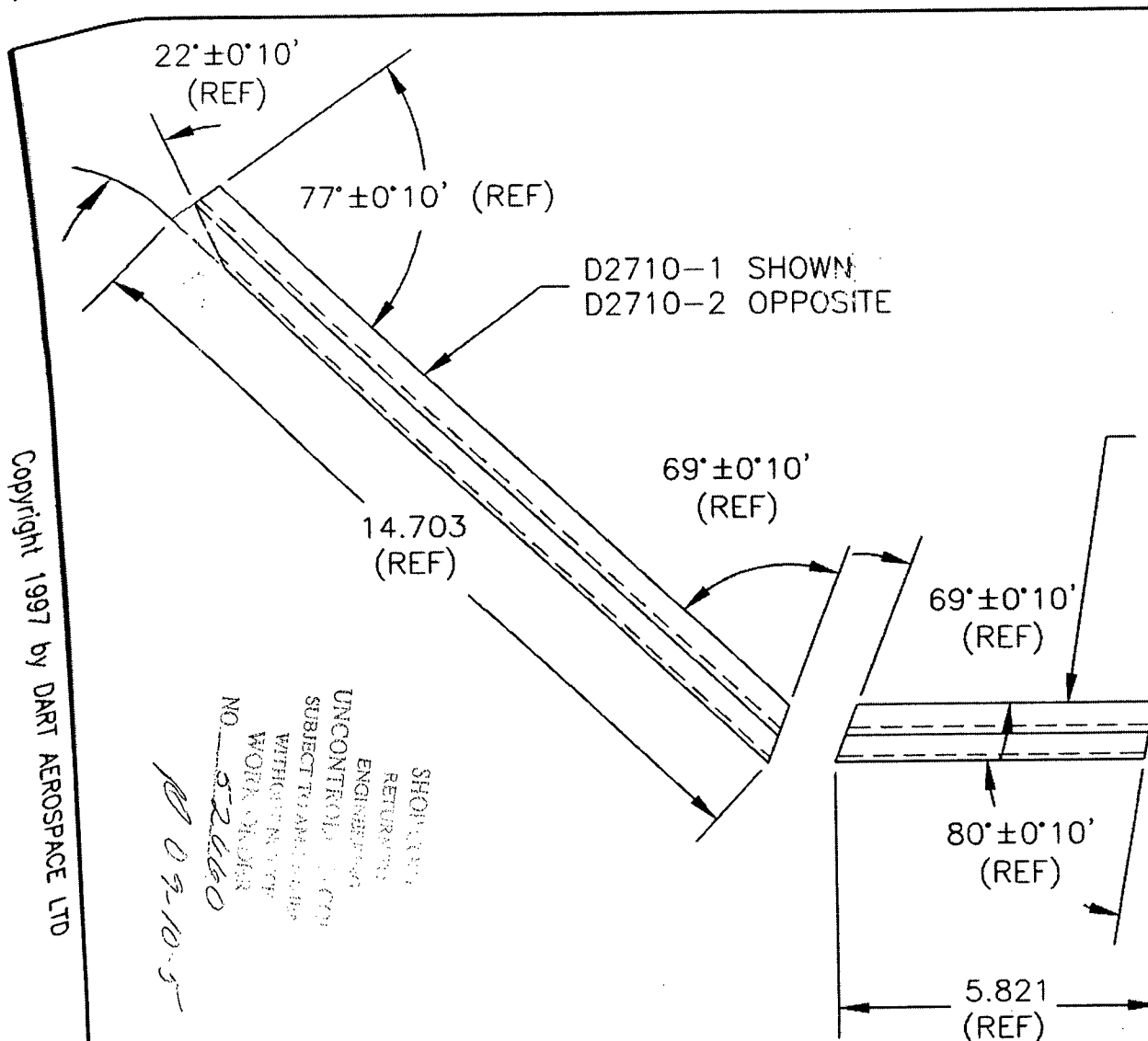
DART



DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	KE	DRAWING NO.	REV. B
				D2710	SHEET 1 OF 1
DATE	99.02.11	TITLE	CONSOLE SIDE RAIL	SCALE	1:3
A	97.10.25	NEW ISSUE			
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)			

D2710-3 SHOWN
D2710-4 OPPOSITE

D2710-1 SHOWN
D2710-2 OPPOSITE



SHOWING
RETURNING
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WORK UNDER
NO. 82460
09-10-5

MATERIAL: MAKE FROM D2024 EXTRUSION
MAKE PER TEMPLATE # DT8264
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RELEASED
1990705 KE